

Work Order ID 73245

Friday, August 26, 2011 10:30:11 AM



Page 1

Item ID:	D3246-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Mounting Bracket					
Start Date:	8/26/2011	Start Qty:	6.00		Cust Item ID:	
Required Date:	9/9/2011	Req'd Qty:	6.00		Customer:	
Reference:						

Approvals:	Process Plan:	<u>CL</u>	Date:	<u>11/08/26</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
D3246	Rev A1								

100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg Dsi9279 <input type="checkbox"/> Dwg Rev: <u>A1</u> <input type="checkbox"/> Prog Rev: <u>A1</u> <input type="checkbox"/> 2-								
<u>2604.050</u>	Debur if necessary								

B11-8-31

(7)

110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

B11-8-31

120		0.00							
	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control									

Suloz/31

(17)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			






NOTE: Date & initial all entries



Work Order ID 73245




Friday, August 26, 2011 10:30:11 AM



Page 2

Item ID: D3246-041 Accept  Setup Start 
Revision ID: Stop 
Item Name: Mounting Bracket
Start Date: 8/26/2011 Start Qty: 6.00  Cust Item ID:
Required Date: 9/9/2011 Req'd Qty: 6.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Brake NC Brake NC	NC BRAKE Memo Deburr Form as per Dwg D3246 C'sink as per Dwg D3246	0.00 0.00 ↳							
140  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
150  HandFinish Hand Finishing	Chemical Conversion Coat per QS1005 4.1 Memo	0.00 0.00							

8/11/09 (7)

8/11/09/15

8/11/10

(7)

7/11/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73245

Friday, August 26, 2011 10:30:11 AM



Page 3

Item ID: D3246-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Mounting Bracket

Start Date: 8/26/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160 QC3- Inspect Part Finish 0.00



QC

Memo

0.00

Quality Control

7 BR 11-11-10.

170 Small Fab 0.00



Small Fab

Memo

0.00

Small Fab

Install Nut Plates as per Dwg D3246

8/26/10 (7)

180 QC5- Inspect part completeness to step on W/O 0.00



QC

Memo

0.00

Quality Control

8/26/10

(7)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73245

Friday, August 26, 2011 10:30:11 AM



Page 4

Item ID: D3246-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Mounting Bracket

Start Date: 8/26/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

Identify as per dwg & Stock Location: ST

0.00



Packaging

Memo

PRP
75999

0.00

Packaging

SP 11-11-11

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/11/14
mr
11-11-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, August 26, 2011 10:30:09 AM

Page 1

Work Order ID: 73245

Parent Item: D3246-041

Parent Item Name: Mounting Bracket




Start Date: 8/26/2011

Required Date: 9/9/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 06-06-22 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS21059L3  Nut Plate		Purchased	No			110	Each	264.0000	4	24			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
				ST301				258					
					118234			58					
					118614			200					
				ST302				6					
					116706			6					
M2024T3S.050  2024-T3 .050 sheet		Purchased	No			170	sf	95.9000	0.3097	1.956			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
				MAT22				95.9					
					117684			95.9					
MS20426AD3-3  Rivet		Purchased	No			170	Each	1,797.000	8	48			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
				ST316				1797					
					19099			1797					

Handwritten signature
8/11/10

28

25

HB11-8-31

⑦

117684

Handwritten signature
8/11/10

56

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

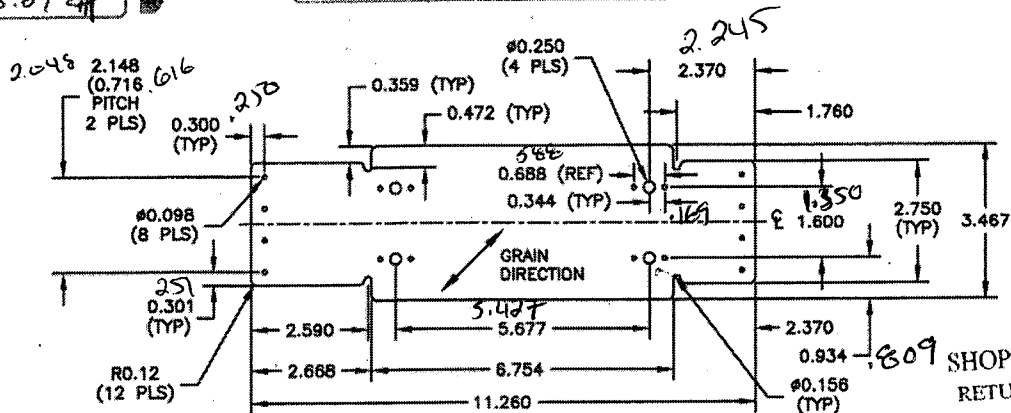
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3246	REV. A SHEET 1 OF 1
DATE 04.04.21		TITLE MOUNTING BRACKET	SCALE 1:4
A	04.04.21	NEW ISSUE	
AI	04.06.16	CHANGE RIVET; ADDED C'SINK	

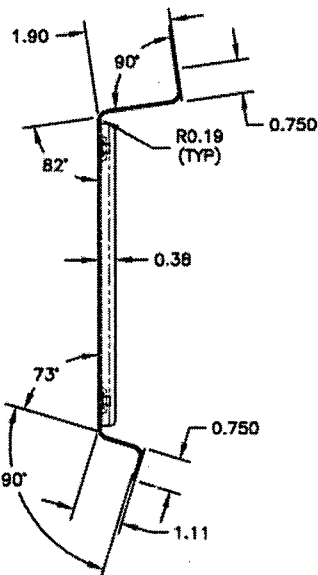
RELEASED
04.05.07



D3246-1 FLAT PATTERN



D3246-1 BEND DETAIL



D3246-041 ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 73245
Call 1108124

MS21059-L3
NUT PLATE (1)
MS20470AD3-4 RIVET (2)
(4 PLACES)
INSTALL AFTER
ALODINE
C'SINK $\phi 0.185 \times 100^\circ$
MS20426AD3-3 RIVET (2)

NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.050 THICK (REF. DART SPEC. M2024T3S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.